

Date: Thursday, 04/12/2008 10:33:21 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT DOUBLER
Job Number : 05062	
Estimate Number : 13278	
P.O. Number :	Part Number : D37031
This Issue : 04/12/2008 S.O. No. :	Drawing Number : D3703 PRELIM FOR ENGINEER USE ONLY
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : R & D SM/MED FAB	Drawing Revision : PRELIM
Previous Run : 43910	Material :
Written By :	Due Date : 11/12/2008 Qty: 3 Um: Each
Checked & Approved By : <u>UMF 08-12-04</u>	
Comment : Est Rev:A 08-04-24 new issue DD verified by:EC	

Additional Product

Job Number:



PROTOTYPE
PRELIMINARY ISSUE
 09.01.16
 ECN# 4

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet
Comment: Qty.: 0.5814 sf(s)/Unit Total: 1.7442 sf(s) 6061T6 aluminium sheet .063" thick (M6061T6S063) Batch: <u>108279</u> <u>LB 8-12-5</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3703 Dwg Rev: <u>PRE</u> Prog Rev: <u>LIN</u> <u>LB 8-12-5</u> (3) ****grain direction along 6.30"**** 2- Deburr if necessary <u>LB 8-12-5</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>LB 8-12-5</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>08-12-05</u> (3)		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Bend as per Dwg D3703 <u>SB 07/01/13</u> (1)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3703-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/06/08
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>05062</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/01/13</u>	<u>5</u>	<u>2 part was scrap send out of Tolerance</u>	<u>09.01.16</u>	<u>Scrap & destroy</u>	<u>S</u> <u>09/01/13</u>	<u>S</u> <u>09/01/16</u>	<u>09.01.16</u>	<u>S</u> <u>09/01/16</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 05062

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Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09-01-14 (3)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09-01-16 (3)

09-01-14

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-14

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 138

9/6/8

50 (2)

50

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/06/08

Job Completion



POSITIVE RECALL

EFFECTIVE

09-01-16

AUTH

DATE

09-06-05

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Prototype

Measured by:	LB	Audited by:	/	Prototype Approval:	/
Date:	9-17-5	Date:	10-12-05	Date:	/

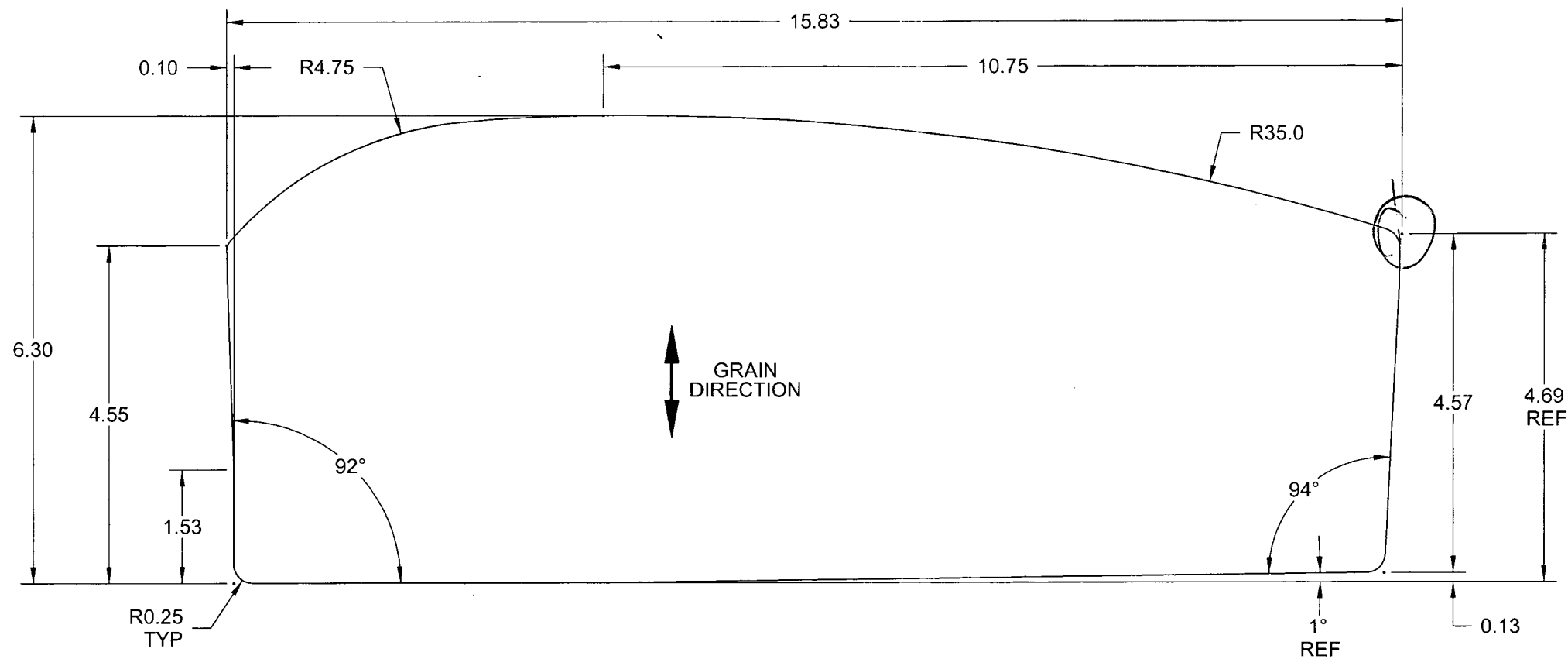
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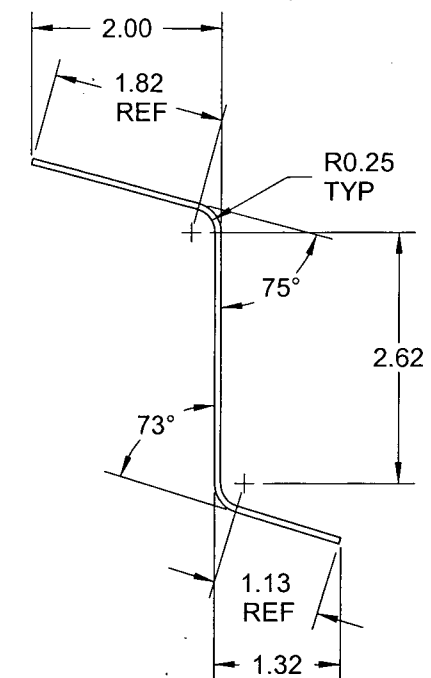
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D3703-1F AFT DOUBLER FLAT PATTERN

**PRELIMINARY
ISSUE**

08/10/31 WP



**D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)**

~~PROTOTYPE~~ 09.01.16

PRELIMINARY ISSUE

09.01.16 PER ENW #09.502P

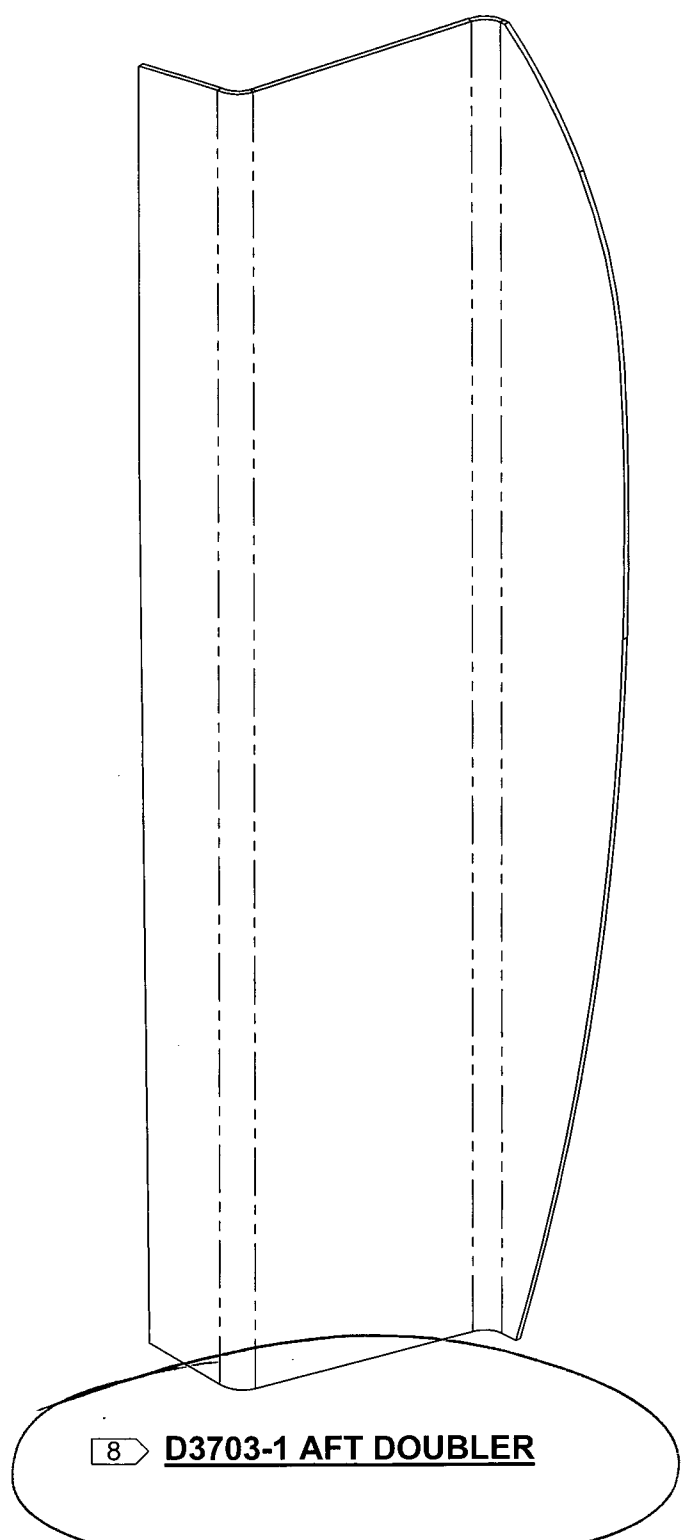
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CHECKED		DRAWING NO. D3703	REV. A
MFG. APPR.			SHEET 2 OF 4
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DATE	08.04.30		

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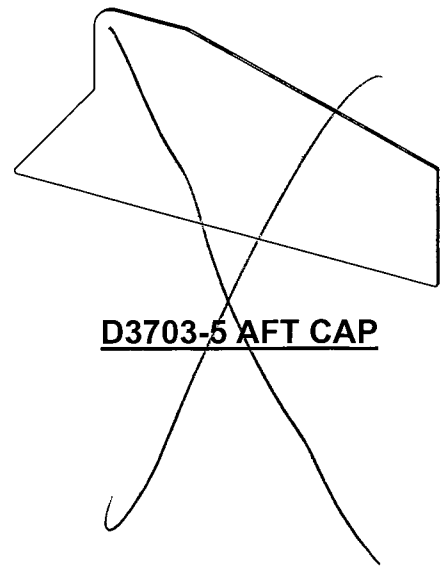
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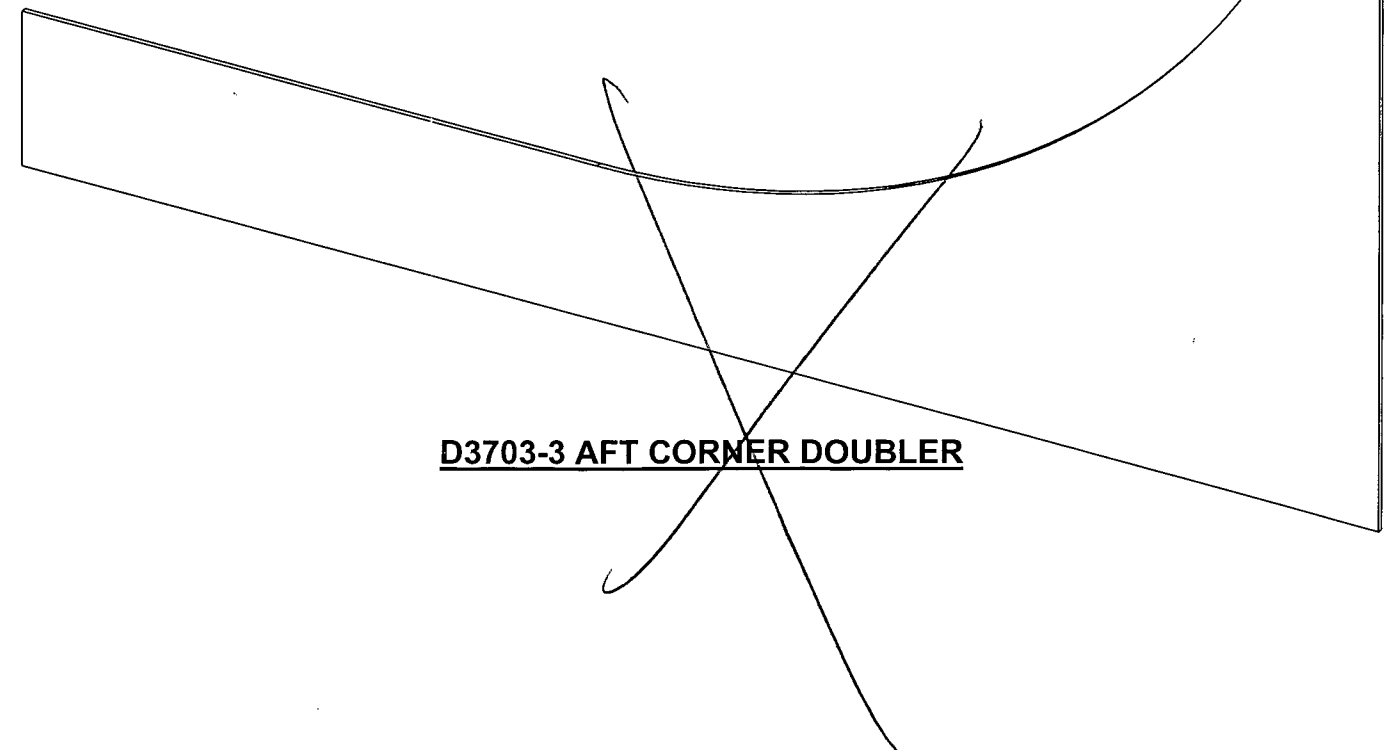
D
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8 D3703-1 AFT DOUBLER



D3703-5 AFT CAP



D3703-3 AFT CORNER DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs
- 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

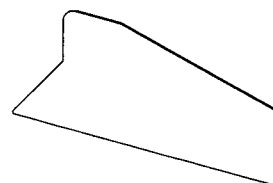
PRELIMINARY
ISSUE
08/10/31 MB

~~PROTOTYPE~~
09.01.16

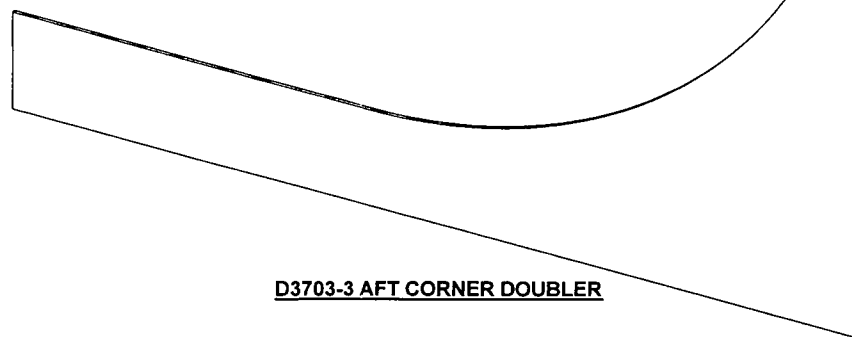
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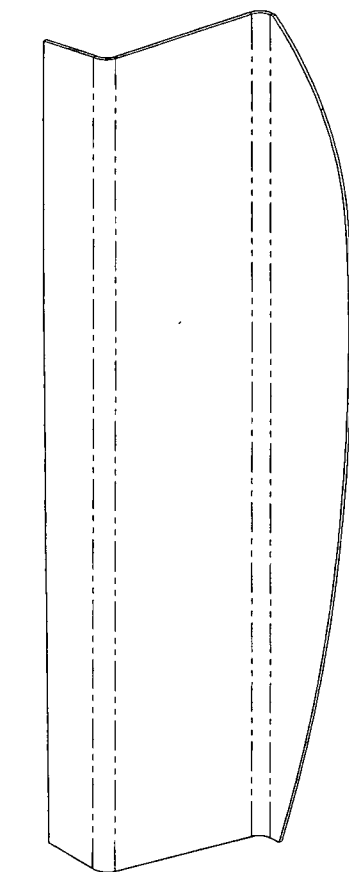
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D3703-5 AFT CAP



D3703-3 AFT CORNER DOUBLER



D3703-1 AFT DOUBLER

NOTES:

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w/o 05062

RELEASED
29/04/09

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8 7 6 5 4 3 2 1

D

C

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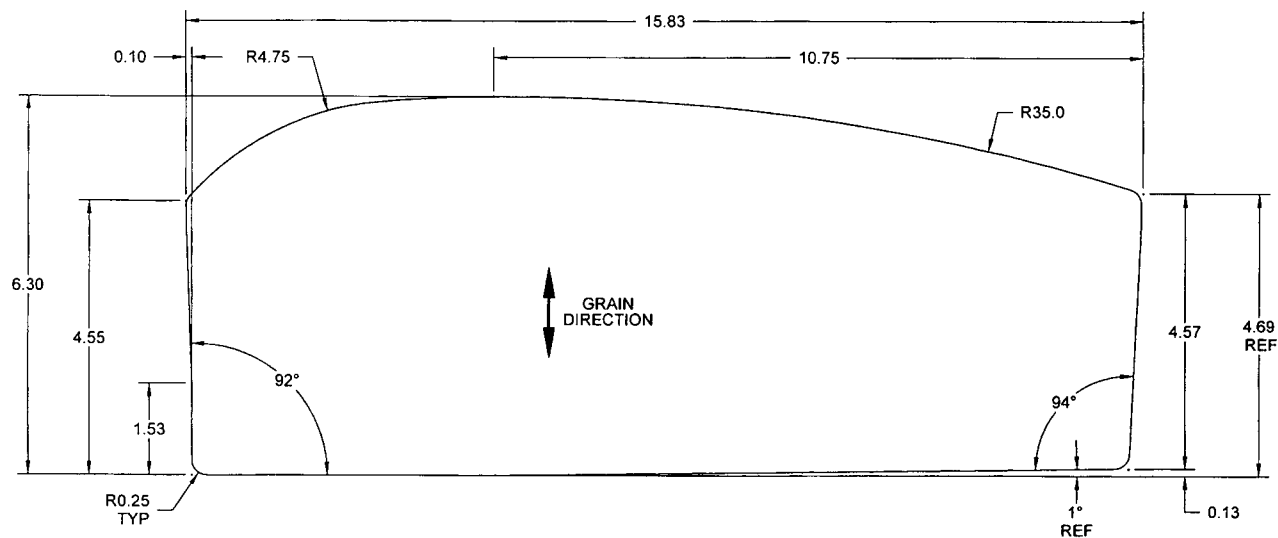
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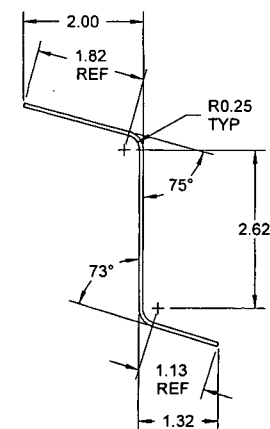
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D3703-1F AFT DOUBLER FLAT PATTERN



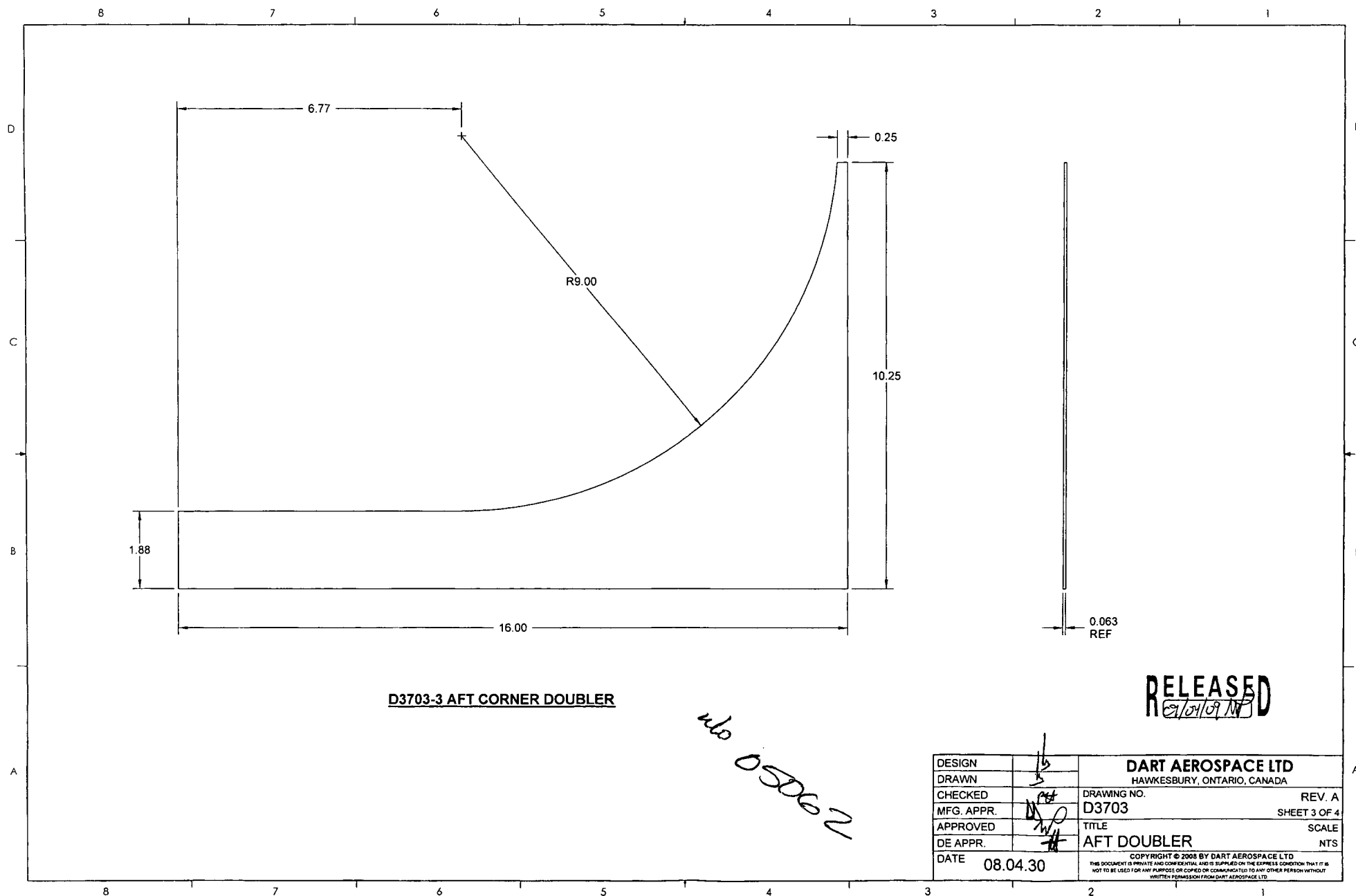
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(MAKE FROM D3703-1F)**

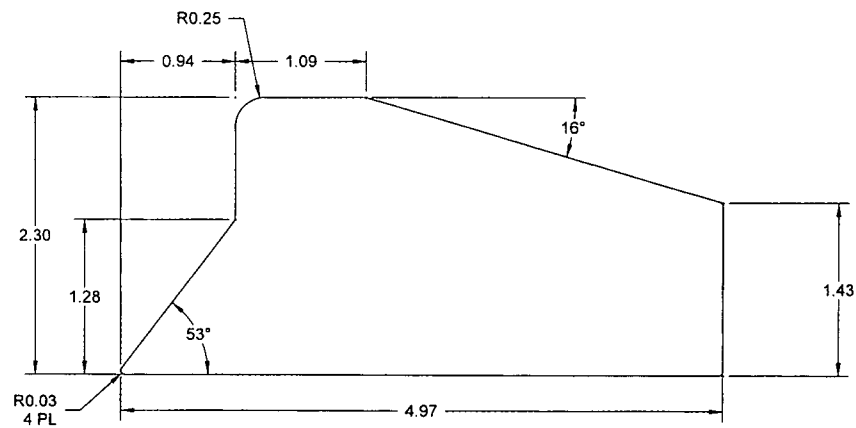
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8 7 6 5 4 3 2 1





D3703-5 AFT CAP

Wb 050622

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09/24/09 AM

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